

Work Order ID 164294

Monday, July 17, 2017 9:21:36 AM

164294

Page 1

Item ID: D4635-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Ceiling Panel, LH
Start Date: 7/21/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	F								

110 0.00
110 THERMOFORMING MACHINE 3 JUL 19 2017 DAS 13 9-89
Purchasing Memo
Purchasing ISSUE P/O: 37108
SUPPLIER: PLASTECH
MANUFACTURE D4635-3 AS PER DWG
C OF C IS REQUIRED

140 0.00
140 Receive & Inspect for Damage & Mat'l Certs
HAND FINISHING THERMOFORMING
Packaging Memo
Packaging 3x SP 17-8-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>F6242</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

③ 17.09.12 PD

① 12/09/12
DAS
07
9-89
17/09/12

② 17/9/18

SEP 13 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
04/11 TD 02/10								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Monday, July 17, 2017 9:21:40 AM

Page 1

Work Order ID: 164294

164294

Parent Item: D4635-3

D4635-3

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update
13/07/09 DL IPP Rev. D Dwg. Update, Material
Change 13/12/18 DL IPP Rev. E Dwg. Update 14/01/09
DL IPP Rev F Dwg, update 15/01/27
DL IPP Rev.G 17.06.13 Now outside process DP
Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-3P		Purchased	No			110	Each	0.0000	1	3			
D4635-3P									**				
Aft Ceiling Panel, LH													
MLEXS.093-F6006-07		Purchased	No			110	sf	1,063.960	9.39	28.17			
MI FXS 093-F6006-07									**				
GE PLASTICS LEXAN SHEET (LIGHT GREY)													

Location

Loc Qty

Loc Code

MAT023

69.56

m129738

69.56

RM

994.4

m135322

194.4

m135517

800

SEP 13 2017

DQA: _____ Date: _____



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Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : _____																							

DQA: _____ Date: _____

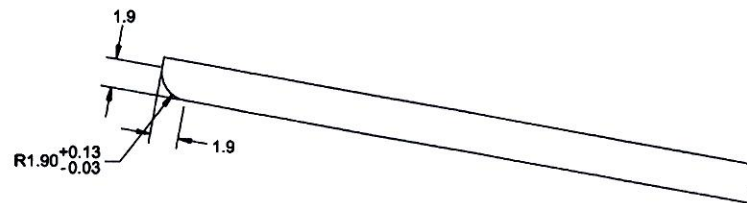
WORK ORDER NON-CONFORMANCE / UPDATE



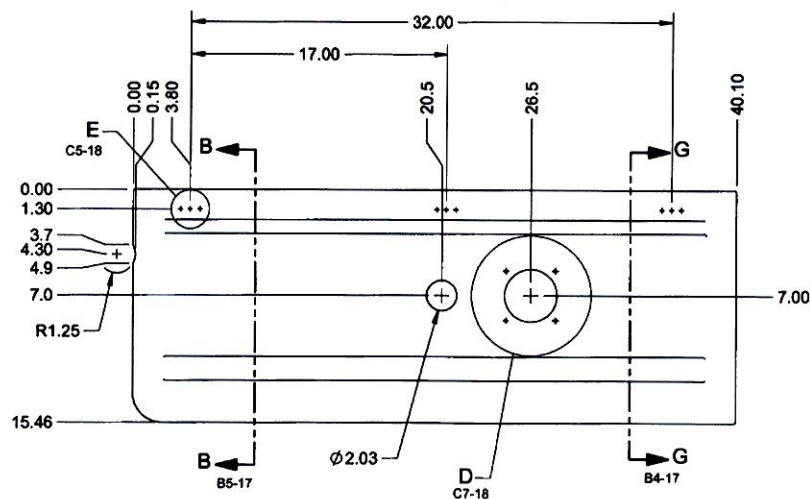
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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

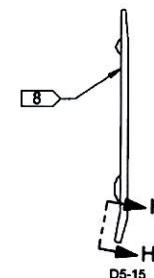


SECTION H-H 82-15



D4635-3 LH. AFT CEILING PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164294 HCS
120717



RELEASED

2015 JAN 26

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.66 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4635	REV. F
MFG. APPR.	DL	SHEET 15 OF 18	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

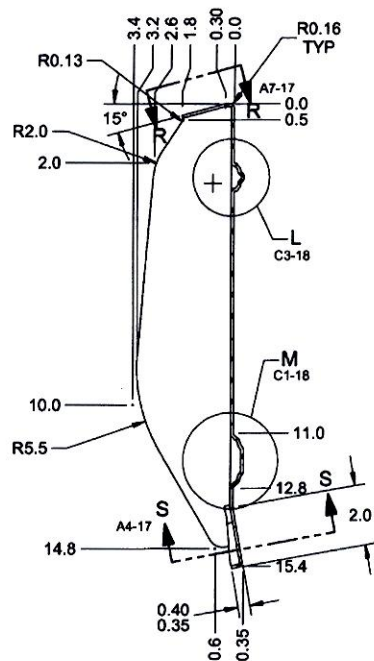


WORK ORDER NON-CONFORMANCE / UPDATE

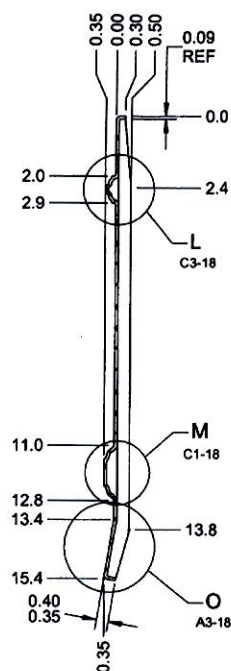
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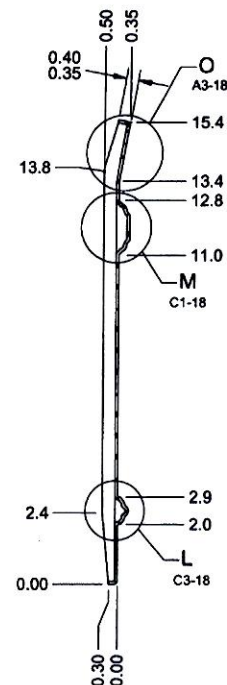
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Misidentified ☐	Past Due ☐																																																																



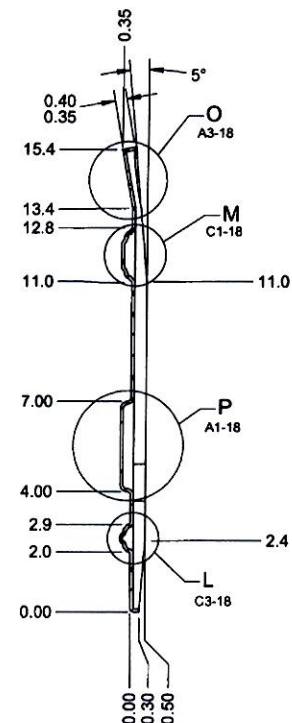
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X



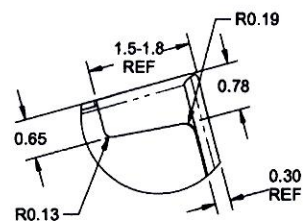
SECTION B-B
SCALE 2X



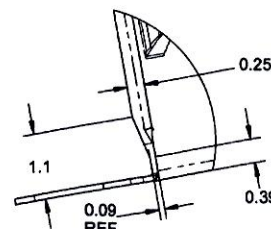
SECTION G-G
SCALE 2X



SECTION K-K
SCALE 2X



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

RELEASED
2015 JAN 26 *qp*

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 17 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____

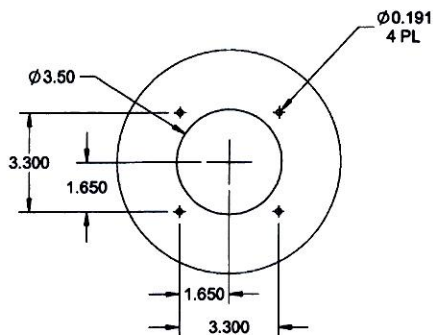


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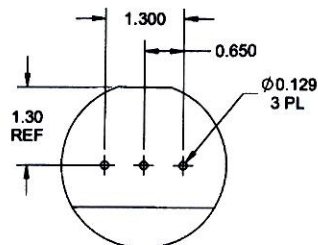
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



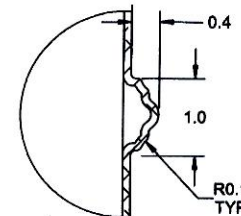
DETAIL D
SCALE 2X

B4-13
B3-14
B5-15
B5-16



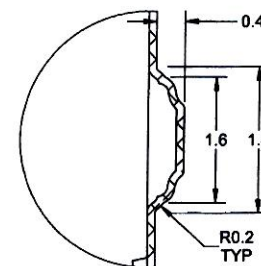
DETAIL E
SCALE 4X

C7-13
B6-14
C6-15
B5-16



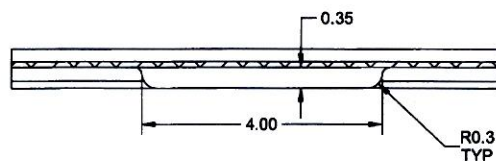
DETAIL I
SCALE 1.5X

B2-17
B4-17
C5-17
C7-17



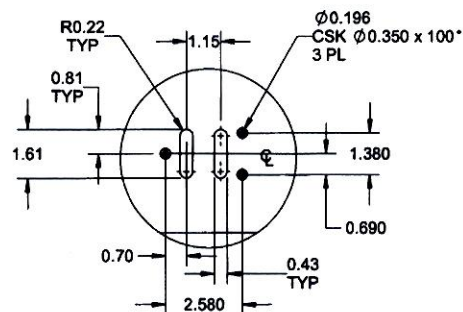
DETAIL M
SCALE 1.5X

C2-17
C3-17
C5-17
C7-17



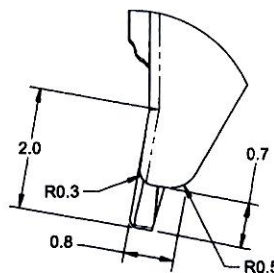
SECTION I-I
SCALE 4X

B5-16



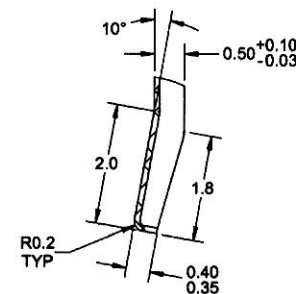
DETAIL Q
SCALE 2X

C5-16



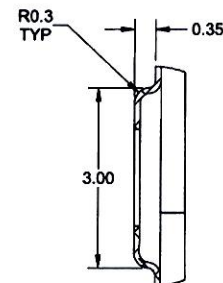
DETAIL N
SCALE 2X

B2-13



DETAIL O
SCALE 2X

D2-17
D3-17
B5-17



DETAIL P
SCALE 4X

C2-17

RELEASED
2015 JAN 26

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	AK
MFG. APPR.	DL
APPROVED	HS
DE APPR.	DS
DATE	14.11.28

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4635** REV. F
SHEET 16 OF 18
TITLE **OUTBOARD CEILING PANELS** SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 6 of 9

Order From :

VC-PLT01

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$400.00

16	D4635-1P	Fwd Ceiling Panel, LH	7/31/2017 Yes 7/31/2017	3.00 Each	\$100.00	\$300.00
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MANUFACTURE AS PER DWG D4635 REV. F
B164292

Line Total: \$300.00

17	D4635-2P	Fwd Ceiling Panel, RH	7/31/2017 Yes 7/31/2017	3.00 Each	\$100.00	\$300.00
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MANUFACTURE AS PER DWG D4635 REV. F
B164293

Line Total: \$300.00

18	D4635-3P	Aft Ceiling Panel, LH	7/31/2017 Yes 7/31/2017	3.00 Each	\$100.00	\$300.00
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MANUFACTURE AS PER DWG D4635 REV. F
B164294

Note:

7/19/2017

SPR-8-30

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24077
Shipment Date: 08/25/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 2 of 2

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
Attn: ROBERT ABOUD
T Buyer Contact: ROBERT ABOUD
O

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
Attn: ROBERT ABOUD
T
O

Item Number - Revision	Description	Quantity Shipped	UOM
D4634-1P - Rev.: G	FWD, CENTER CEILING PANEL HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4634-3P - Rev.: G	MIDDLE, CENTER CEILING PANEL HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4634-5P - Rev.: G	AFT, CENTER CEILING PANEL HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4635-1 - Rev.: F	FWD CEILING PANEL, LH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4635-2 - Rev.: F	FWD CEILING PANEL, RH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4635-3 - Rev.: F	AFT CEILING PANEL, LH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA
D4635-4 - Rev.: F	AFT CEILING PANEL, RH AS PER DWG D4635 REV. F HS Code: 3920.61.1000 - OTHER Country of Origin : CA	3	EA

SP17-8-30

3 EA

Number of Containers

Gross Weight

Shipped By